

Work Order ID 159864

Wednesday, April 19, 2017 11:30:01 AM

159864

Page 1

Item ID: D3243-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 4/24/2017 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 5/8/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: SCHEDULED/S DAS
Approvals: Process Plan: 9-89 Date: APR 19 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3243	Rev A								

110

0.00

110

Waterjet

FLOW CNC Waterjet

HAAS CNC VERTICAL MACHINING #1

Memo

0.50

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

(8)

04/17/05/13

120

0.00

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.06

(8)

04/17/05/13

Wednesday, April 19, 2017 11:30:01 AM

Page 2

JUN 19 2017

Work Order ID 159864

Wednesday, April 19, 2017 11:30:01 AM

159864

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Chemical Conversion Coat per QSI005 4.1	0.00							
170									
HandFinish	Memo	0.50				(X8)	0		2017/06/20
Hand Finishing									BETB.
180	Small Fab	0.00							
180									
Small Fab	Memo	0.21				8X			17/06/21
Small Fab	Install Inserts as per Dwg D3343								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.12				3			JUN 21 2017
Quality Control									

DAS
30
9-89

Work Order ID 159864

Wednesday, April 19, 2017 11:30:01 AM

159864

Page 4

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Required Date: 5/8/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200 *200* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>M 136370.</i> Memo *****Mask Holes***** START TIME: <i>2:30.</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>3:00.</i>	0.00 0.42				<i>8</i>	<i>φ</i>	<i>17-06-21.</i>	<i>8 34 0.89</i>
210 *210* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.06				<i>8</i>			<i>DAS 38 9-88 JUN 22 2017</i>
220 *220* Packaging Packaging	Identify as per dwg & Stock Location: <i>S480</i> Memo	0.00 0.06				<i>8</i>		<i>JUN 22 2017</i>	<i>DAS 6 9-89</i>

Work Order ID 159864

Wednesday, April 19, 2017 11:30:01 AM

159864

Page 5

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Required Date: 5/8/2017 Req'd Qty: 6.00 ***6*** Customer:
Reference: SCHEDULED/S

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC21- Final Inspection - Work Order Release	0.00							
230									
QC	Memo	0.60							
Quality Control									

17/6/27 *[Signature]*

DAS
21
9-89

JUN 22 2017

Picklist Print

Wednesday, April 19, 2017 11:30:01 AM

Page 1

Work Order ID: 159864

159864

Parent Item: D3243-041

D3243-041

Parent Item Name: Bracket

Start Date: 4/24/2017

Required Date: 5/8/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-032-EF		Purchased	No			180	Each	33.0000	4	24			
FF-032-EF									**			17/06/21	DAS 36 9-89
Inserts Alt: FE-032-MD													

Location	Loc Qty	Loc Code
GA	32	
m134890	7	
m135544	1	
m136295	24	
ST559	1	
m134202	1	

M6061T6S.063

Purchased

No

110 sf

240.9460

0.5499

3.473053

M6061T6S 063

6061-T6 .063 Sheet

02/17/05/13

Location	Loc Qty	Loc Code
MAT021	240.946	
M134604	68.17	
M134830	2.456	
M136251	31.9	
M136790	9.9	
M136896	18.8	
M137041	59.72	
M137175	50	

3
1

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

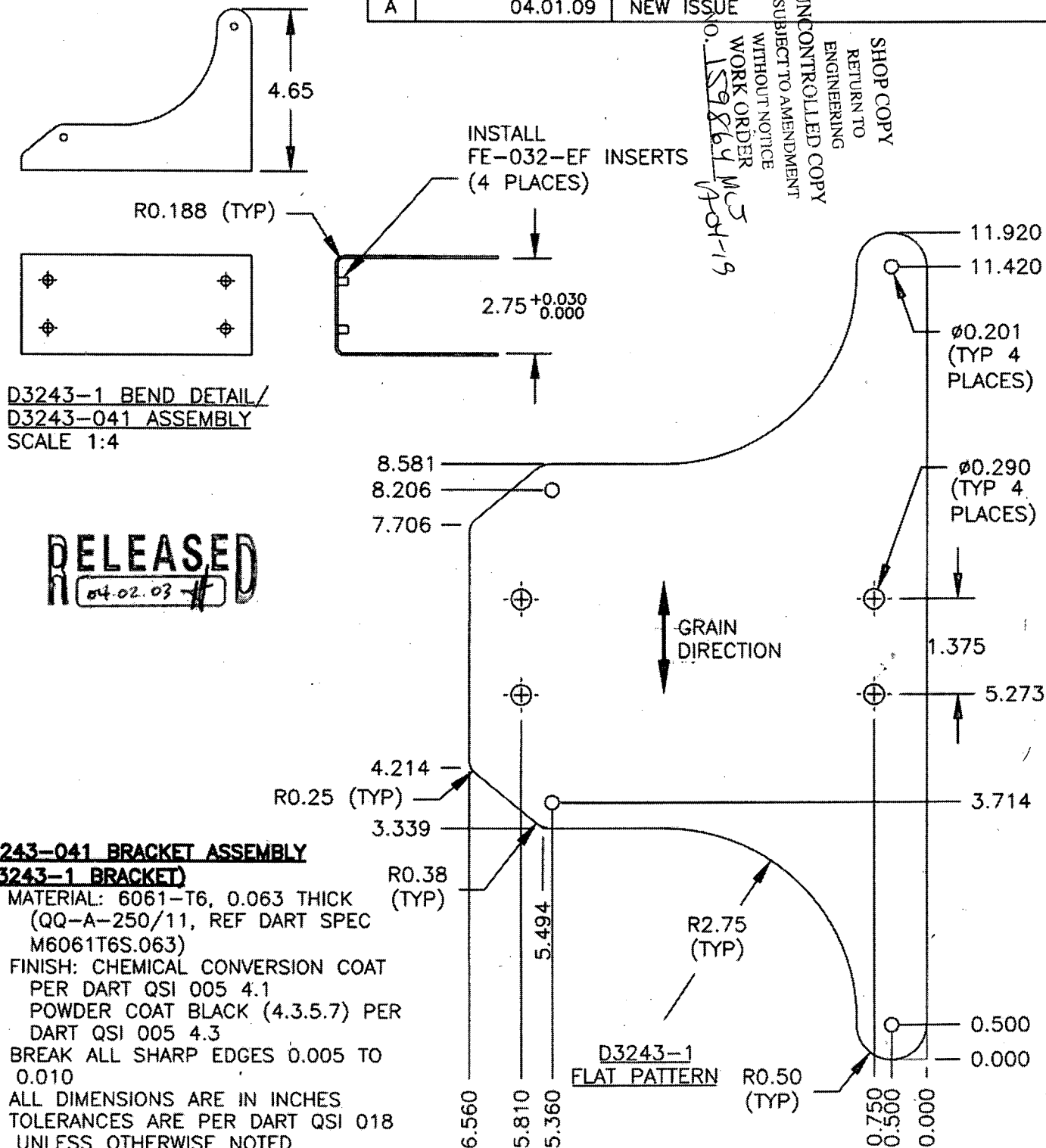
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3243	SHEET 1 OF 1
DATE		TITLE	SCALE
04.01.09		BRACKET	1:2
A	04.01.09	NEW ISSUE	UN



D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)

- 1) MATERIAL: 6061-T6, 0.063 THICK (QQ-A-250/11, REF DART SPEC M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					